

~~12~~ 1:51:12 PM

Page 1

D412-769-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Facing Seat Assembly, LH

Stop *NS2*

Start Date: 16/03/2012 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 30/03/2012 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/16

Tooling:

Date:

Run Start *NR1*

QC: _____

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81647

81647

Page 2

March-16-12 1:51:12 PM

Item ID: D412-769-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Facing Seat Assembly, LH

Stop

NS2

Start Date: 16/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1- mask D3782-041 and D3782-043 front legs and D3787-1 foot as per dwg D412-769-041

2- install bolts in 3 place (in seat belt eye bolt holes) to ensure leg does not move when Powdercoat

3- Powder coat remainig of assembly grey as per dwg D412-769-1START

Start Time: 11:45
Temp: 3200F
Finish Time: 12:15

IX
12/05/14

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

1
12-05-14

150

Pick Kit

0.00

150

Packaging

Memo

0.00

Packaging

①
FF 12-05-14

W117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81647

Page 3

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 16/03/2012 **Start Qty:** 1.00 ***1***

Required Date: 30/03/2012 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Run Start *NR1*

Stop *NR2*

160

Memo

0.00

Small Fab

1- install remaining parts as per dwg D412-769-1

170

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

180

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81647***81647***

Page 4

March-16-12 1:51:12 PM

Item ID: D412-769-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Aft Facing Seat Assembly, LH

Stop ***NS2***

Start Date: 16/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00


190

QC

Memo

0.00

Quality Control

12/15/15 
MF 12-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 1:51:16 PM

Page 1

Work Order ID: 81647

81647

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 08.05-12 new issue DD verified by:EC
 IPP Rev:B 08-07-17 revB as per dwg DD verified by:ec
 IPP Rev:C 08-08-21 move D3792-1 after powder coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-5A		Purchased	No			110	Each	1,168.000	6	6			
AN3-5A													
Bolt													

Location	Loc Qty	Loc Code
ST350	1168	
115371	46	
117423	204	
118626	218	
119355	200	
120187	500	

AN4-15A		Purchased	No			110	Each	367.0000	2	2			
AN4-15A													
Bolt													

Location	Loc Qty	Loc Code
GA	100	
120449	100	
ST358	267	
118706	15	
120187	52	
120422	200	

Handwritten notes and signatures:

Signature: *[Signature]* 12/05/14

M12/185 (6x)

Signature: *[Signature]* 12/05/14

2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 1:51:16 PM

Page 2

Work Order ID: 81647

81647

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN45-13A

Purchased

No

110

Each

30.0000

1

1

AN45-13A

EYE BOLT

**

Location

Loc Qty

Loc Code

ST362

30

115358

12

118757

10

118758

8

AN5-10A

Purchased

No

110

Each

394.0000

6

6

AN5-10A

Bolt

**

Location

Loc Qty

Loc Code

ST337

394

118191

80

120630

50

120717

50

120770

214

AN5-13A

Purchased

No

110

Each

60.0000

2

2

AN5-13A

Bolt

**

Location

Loc Qty

Loc Code

GA

20

116003

20

ST338

40

118983

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 1:51:16 PM

Page 3

Work Order ID: 81647

81647

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN525-10R24

Purchased

No

110

Each

148.0000

9

9

AN525-10R24

Screw

**

Location

Loc Qty

Loc Code

ST346

148

114056

48

117619

100

AN960JD10

NAS1149D0363J

Purchased

No

110

Each

0.0000

21

21

AN960.ID10

Washer

**

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

14.0000

4

4

AN960.ID416

Washer

**

Location

Loc Qty

Loc Code

ST351

14

116289

14

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

20

20

AN960.ID516

Washer

**

D3766-1

Manufactured

No

110

Each

3.0000

1

1

D3766-1

Front Rail, LH

**

Location

Loc Qty

Loc Code

ST254

3

62067

3

March-16-12 1:51:16 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 1:51:16 PM

Page 4

Work Order ID: 81647

81647

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3766-3
D3766-3
 Rear Rail

Manufactured No

110 Each 4.0000 1 1

**

Location

Loc Qty

Loc Code

ST254

4

74739

4

D3767-1
D3767-1
 Upper Rail

Manufactured No

110 Each 1.0000 1 1

**

Location

Loc Qty

Loc Code

ST254

1

77597

1

D3782-041
D3782-041
 Front Inboard Leg Assembly

Manufactured No

110 Each 0.0000 1 1

**

D3782-043
D3782-043
 Front Outboard Leg Assembly, LH

Manufactured No

110 Each 3.0000 1 1

**

Location

Loc Qty

Loc Code

GA

1

78274

1

ST249

2

79361

2

D3782-045
D3782-045
 Back Leg Assembly

Manufactured No

110 Each 2.0000 2 2

**

Location

Loc Qty

Loc Code

ST256

2

74701

2

EP 12/05/14

EP 12/05/14

B81697 (R) EP 12/05/14

EP 12/05/14

EP 12/05/14

B81686 (2x)

March-16-12 1:51:16 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 1:51:16 PM

Page 5

Work Order ID: 81647

81647

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3783-041 Manufactured No

110 Each 1.0000 1 1

D3783-041

Lateral Brace Assembly

**

Location

Loc Qty

Loc Code

ST249A

1

74742

1

D3783-043 Manufactured No

110 Each 4.0000 2 2

D3783-043

Longitudinal Brace Assembly

**

Location

Loc Qty

Loc Code

ST249

4

79091

4

D3783-045 Manufactured No

110 Each 0.0000 1 1

D3783-045

Angle Brace Assembly

**

B79309 (12)

D3784-041 Manufactured No

110 Each 2.0000 1 1

D3784-041

Seat Support Assembly, Center

**

Location

Loc Qty

Loc Code

ST249A

2

63079

2

D3784-043 Manufactured No

110 Each 0.0000 1 1

D3784-043

Seat Support Assembly, LH

**

B81679 (12)

D3784-044 Manufactured No

110 Each 0.0000 1 1

D3784-044

Seat Support Assembly, RH

**

B81675 (12)

March-16-12 1:51:16 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 1:51:16 PM

Page 6

Work Order ID: 81647

81647

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No
MS21042I 3
Nut

110 Each 3,041.000 9 9

**

Location	Loc Qty	Loc Code
ST300	3041	
117441	16	
117885	32	
118451	5	
118927	3	
119017	2812	
119075	173	

SP 12/05/14

MS21042L4 Purchased No
MS21042I 4
Nut

110 Each 5,519.000 2 2

**

Location	Loc Qty	Loc Code
ST300	5519	
117441	51	
117601	157	
118451	133	
119017	200	
119075	2978	
121011	2000	

SP 12/05/14

AN525-10R22 Purchased No
AN525-10R22
Screw

160 Each 67.0000 13 13

**

Location	Loc Qty	Loc Code
ST346	67	
113595	17	
119309	50	

13

AN960JD10L NAS1149D0332J Purchased No
*AN960.ID10I *
Washer

160 Each 0.0000 13 13

**

M12101

13

① FF 12-05-14

March-16-12 1:51:16 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 1:51:16 PM

Page 7

Work Order ID: 81647

81647

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3774-1
D3774-1
Seat Bottom, LH/RH

Manufactured No

160 Each 4.0000 1 1

**

① FF 12-05-14

Location

Loc Qty

Loc Code

ST257

4

74740

4

D3774-3
D3774-3
Seat Back, LH/RH

Manufactured No

160 Each 3.0000 1 1

**

① FF 12-05-14

Location

Loc Qty

Loc Code

ST257

3

74741

3

D3775-1
D3775-1
Guard

Manufactured No

160 Each 5.0000 2 2

**

① FF 12-05-14

Location

Loc Qty

Loc Code

ST250A

5

62004

1

65059

4

D3792-1
D3792-1
Seat Belt Eye Bolt

Manufactured No

160 Each 31.0000 3 3

**

① FF 12-05-14

Location

Loc Qty

Loc Code

ST249A

31

42020

8

55921

23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 1:51:16 PM

Page 8

Work Order ID: 81647

81647

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

160

Each

3,041.000

19

19

MS21042I 3

**

FF 12-05-14

Nut

Location

Loc Qty

Loc Code

ST300

121349

3041

117441

16

117885

32

118451

5

118927

3

119017

2812

119075

173

110
~~160~~

Each

1,598.000

12

12

**

FF 12/05/14

MS21042L5

Purchased

No

MS21042I 5

Nut

Location

Loc Qty

Loc Code

ST300

1598

116105

5

116548

43

117611

42

118179

8

119109

1500

12
12
12

FF 12-05-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

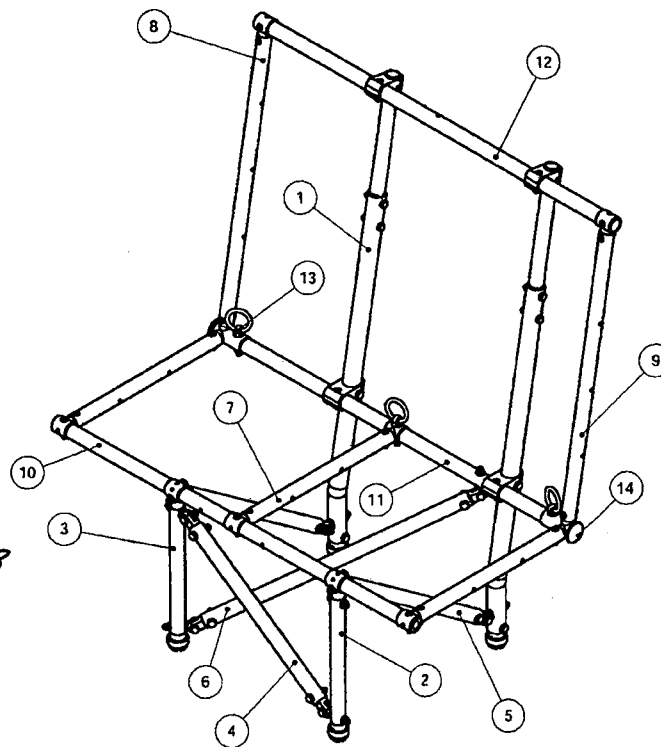
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81647

1205-3



Item Number	Part Number	Description	Quantity (-043)
1	D3782-045	Back Leg Assembly	2
2	D3782-041	Front Inboard Leg Assembly	1
3	D3782-043	Front Outboard Leg Assembly	1
4	D3783-041	Lateral Brace Assembly	1
5	D3783-043	Longitudinal Brace Assembly	2
6	D3783-045	Angle Brace Assembly	1
7	D3784-041	Seat Support Assembly	1
8	D3784-043	Seat Support Assembly, LH	1
9	D3784-044	Seat Support Assembly, RH	1
10	D3766-1	Front Rail	1
11	D3766-3	Rear Rail	1
12	D3767-1	Upper Rail	1
13	D3792-1	Seat Belt Eye Bolt	3
14	D3775-1	Guard	2
15	D3774-1	Seat Bottom (Not Shown)	1
16	D3774-3	Seat Back (Not Shown)	1

Figure 25-11: D412-769-043 Aft Facing Seat Assembly, LH

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25-00-00

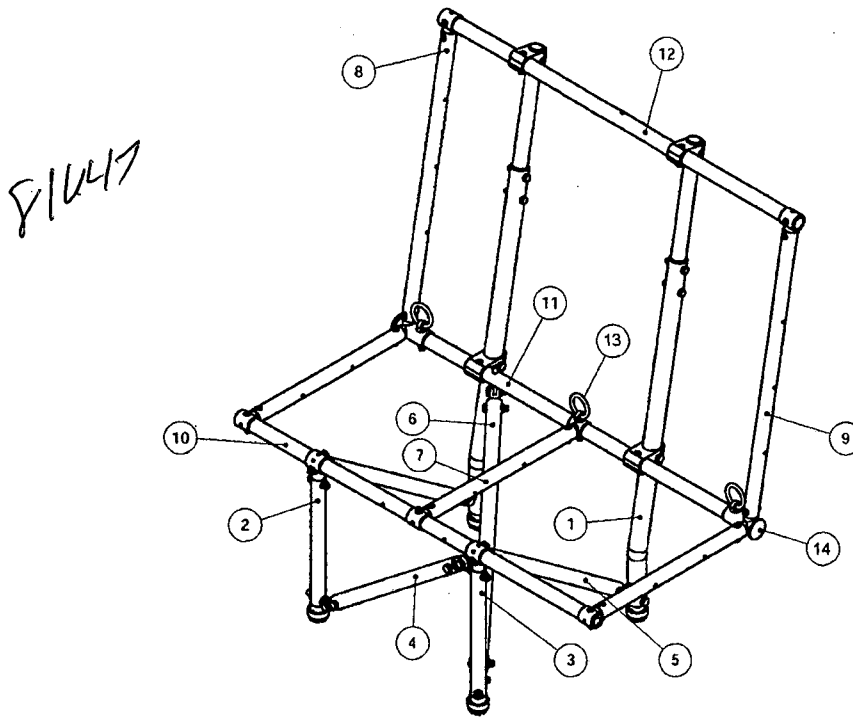
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Item Number	Part Number	Description	Quantity (-044)
1	D3782-045	Back Leg Assembly	2
2	D3782-041	Front Inboard Leg Assembly	1
3	D3782-044	Front Outboard Leg Assembly	1
4	D3783-041	Lateral Brace Assembly	1
5	D3783-043	Longitudinal Brace Assembly	2
6	D3783-045	Angle Brace Assembly	1
7	D3784-041	Seat Support Assembly	1
8	D3784-043	Seat Support Assembly, LH	1
9	D3784-044	Seat Support Assembly, RH	1
10	D3766-2	Front Rail	1
11	D3766-3	Rear Rail	1
12	D3767-1	Upper Rail	1
13	D3792-1	Seat Belt Eye Bolt	3
14	D3775-1	Guard	2
15	D3774-1	Seat Bottom (Not Shown)	1
16	D3774-3	Seat Back (Not Shown)	1

Figure 25-12: D412-769-044 Aft Facing Seat Assembly, RH

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25-00-00

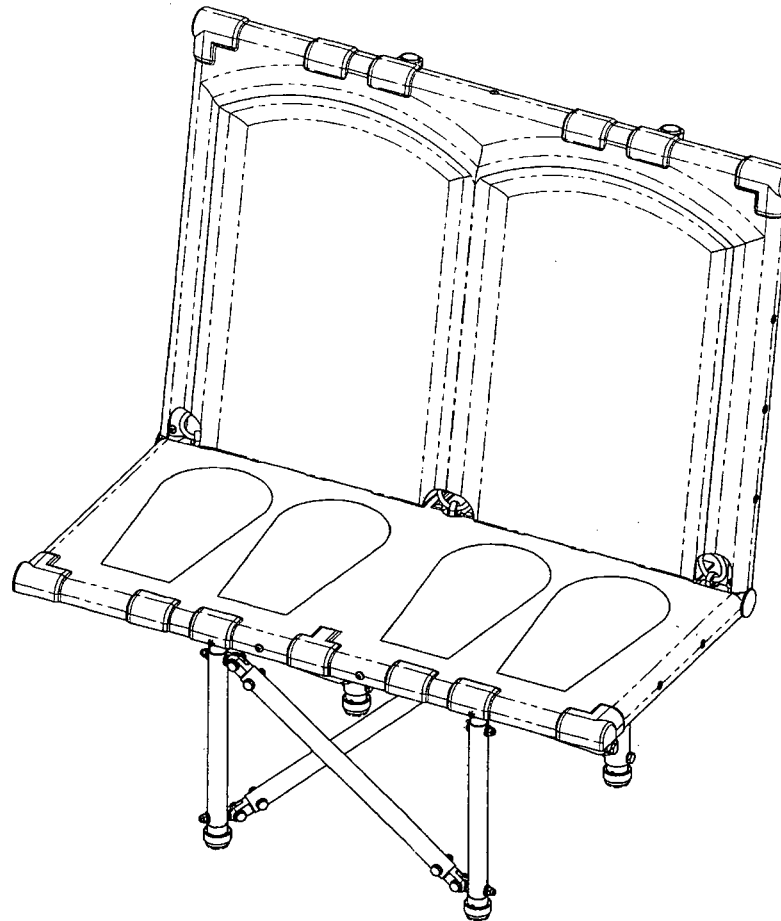
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D412-769-043 AFT FACING SEAT ASSY, LH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 81647 *MCJ*
17/05/14

RELEASED
08.07.09

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D412-769-1 REV. B SHEET 1 OF 7 TITLE AFT FACING SEAT ASSY, LH SCALE NTS	
DRAWN	HS		
CHECKED	<i>PA</i>		
MFG. APPR.	<i>PA</i>		
APPROVED	<i>PA</i>		
DE APPR.	<i>PA</i>	DATE 08.06.25	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

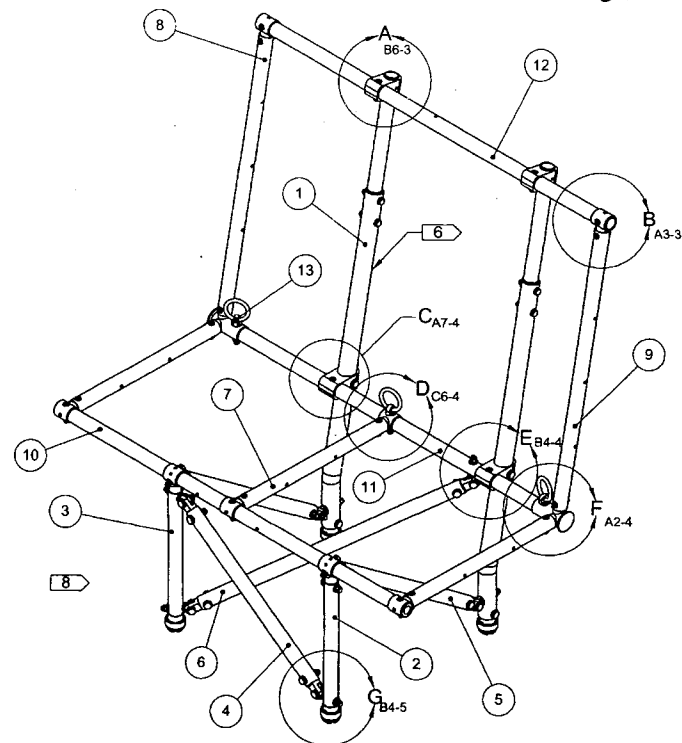
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY



D412-769-043 AFT FACING SEAT ASSY, LH

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D412-769-1	SHEET 2 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	AFT FACING SEAT ASSY, LH	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

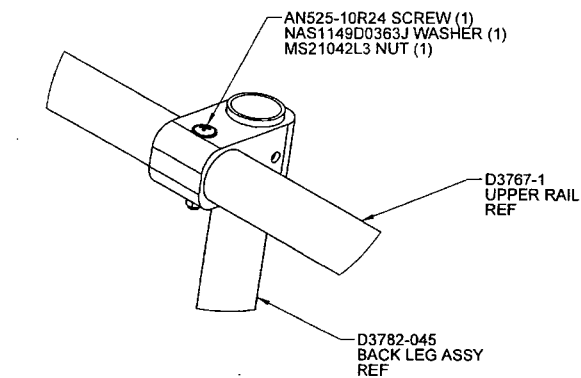
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

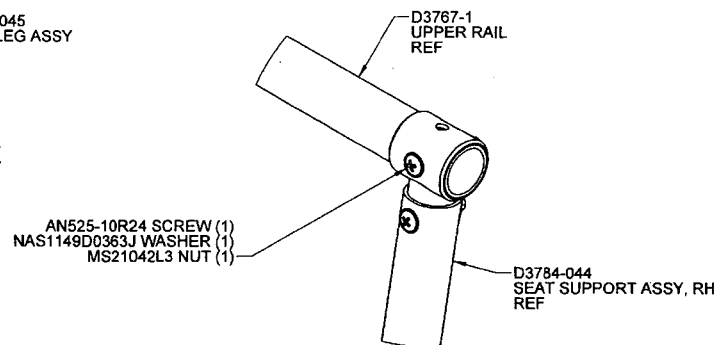
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81647



DETAIL A D2-2
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL



DETAIL B C1-2
SEAT SUPPORT END ATTACHMENT
5 PL

RELEASED
08.07.09

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D412-769-1	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT FACING SEAT ASSY, LH	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

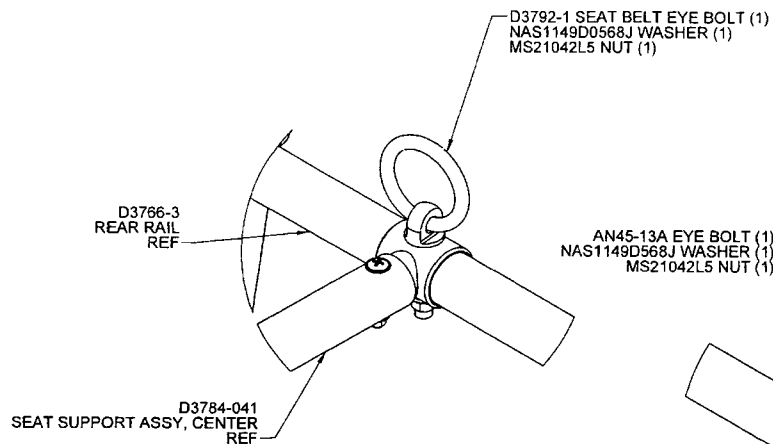
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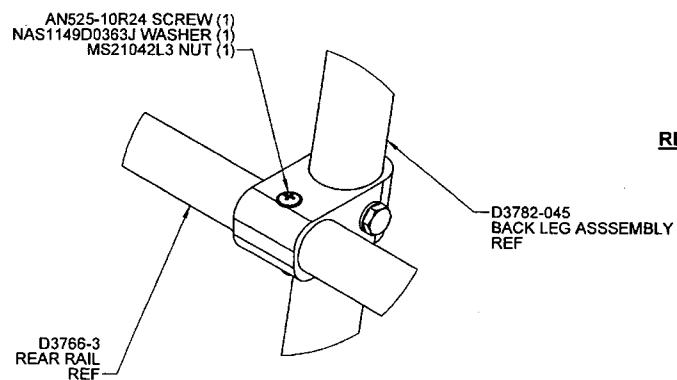
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

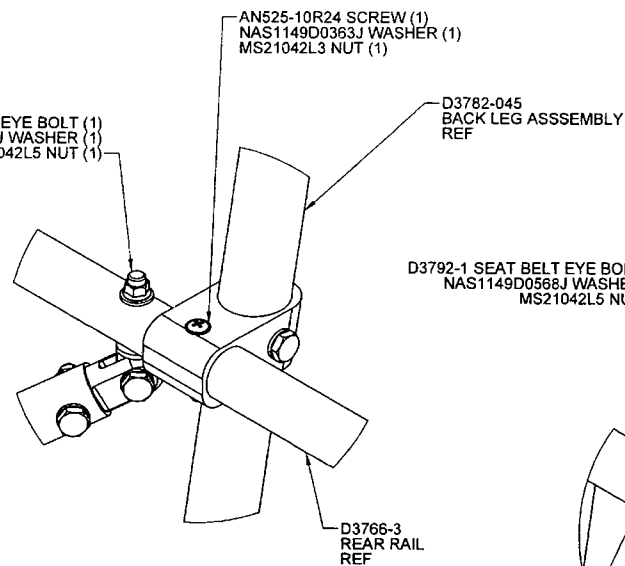
81647



DETAIL D C2-2
SEAT SUPPORT ASSY, CENTER ATTACHMENT



DETAIL C C2-2
REAR RAIL TO BACK LEG ATTACHMENT



DETAIL E C1-2
REAR RAIL TO BACK LEG ATTACHMENT



DETAIL F B1-2
SEAT SUPPORT ATTACHMENT
2 PL

RELEASE
08.07.09.11.12

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

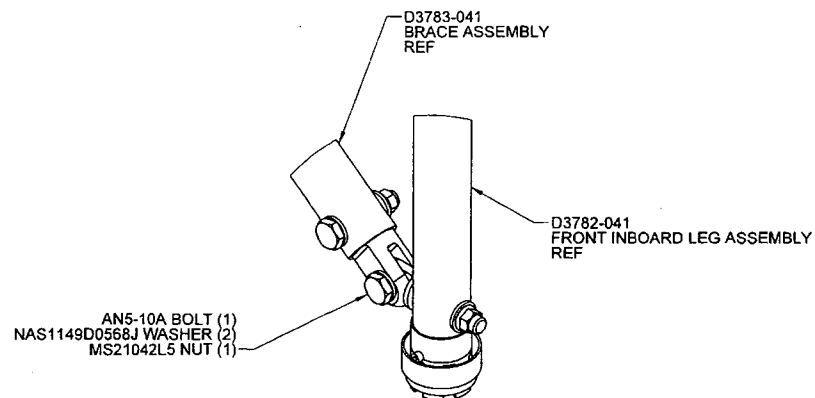
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81647



DETAIL G B2-2
BRACE ATTACHMENT
6 PL

RELEASED
08.07.07/11/07

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	AS	DRAWING NO.	REV. B
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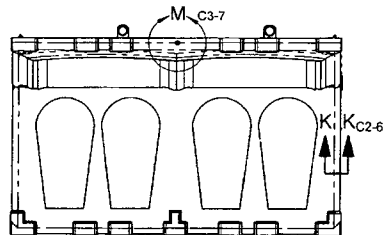
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
3 PL PER SIDE

D3784-044
SEAT SUPPORT, RH
REF

AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
2 PL PER SIDE

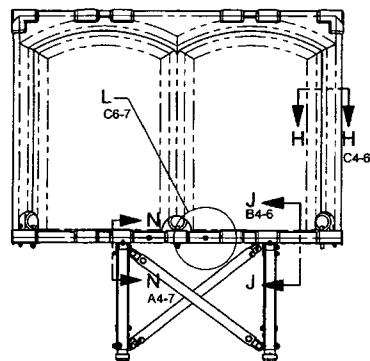
D3774-1
SEAT BOTTOM
REF

D3774-3
SEAT BACK
REF

D3784-044
SEAT SUPPORT, RH
REF

SECTION H-H
B7-6

SECTION K-K
D7-6



D3766-1
FRONT RAIL
REF

SECTION J-J
A7-6

D3774-3
SEAT BACK
REF

D3774-1
SEAT BOTTOM
REF




D3766-3
REAR RAIL
REF

AN3-5A BOLT (1)
NAS1149D0363J WASHER (2)
MS21042L3 NUT (1)
6 PL

RELEASED
10/5/81

NOTES:

- 1) TRANSFER DRILL Ø0.201 FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
- 2) TRANSFER DRILL Ø0.201 FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
- 3) TRANSFER DRILL Ø0.201 FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 6 OF 7
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DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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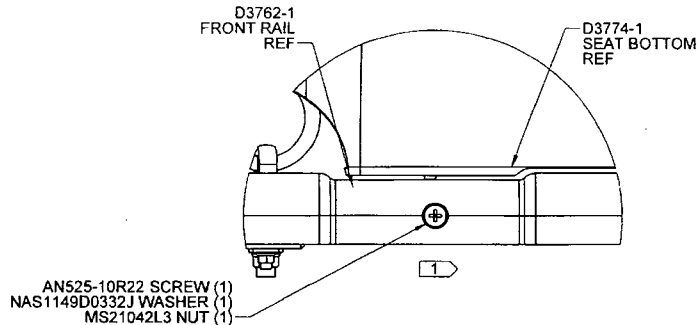
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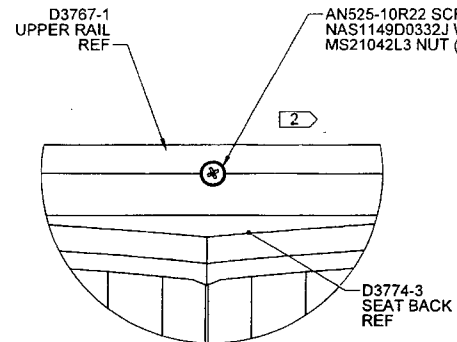
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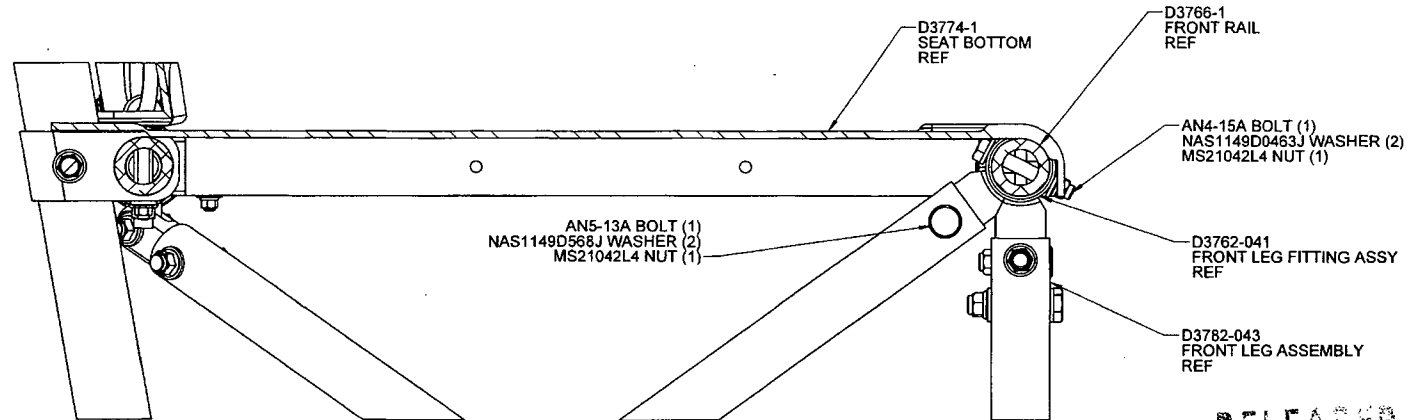
NOTE: Date & initial all entries



DETAIL L A7-6
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL



DETAIL M D7-6
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N A8-6
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT
2 PL

NOTES:

- 1) TRANSFER DRILL $\varnothing 0.201$ FROM FRONT RAIL (D3766-1) TO SEAT BOTTOM (D3774-1) - 2 PL
- 2) TRANSFER DRILL $\varnothing 0.201$ FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

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RELEASED
08-07-2010

21647

W/O:		WORK ORDER CHANGES					
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